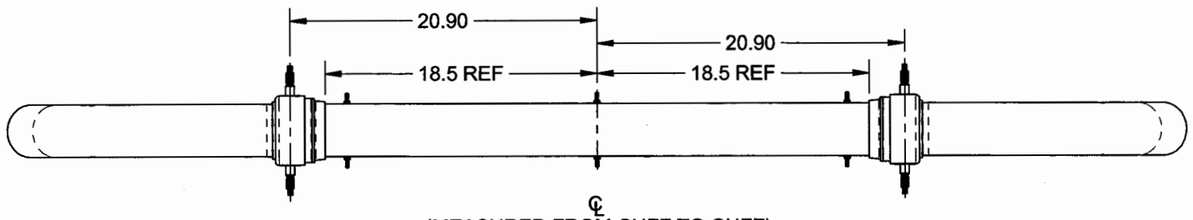
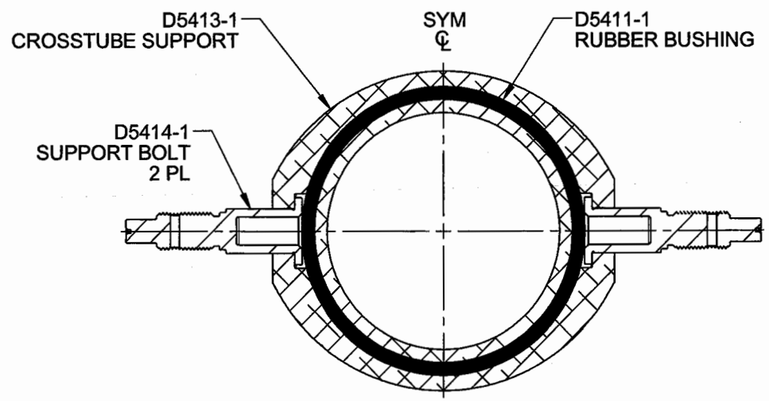
RELEASE DATE 2023.05.08- REF ECR 425

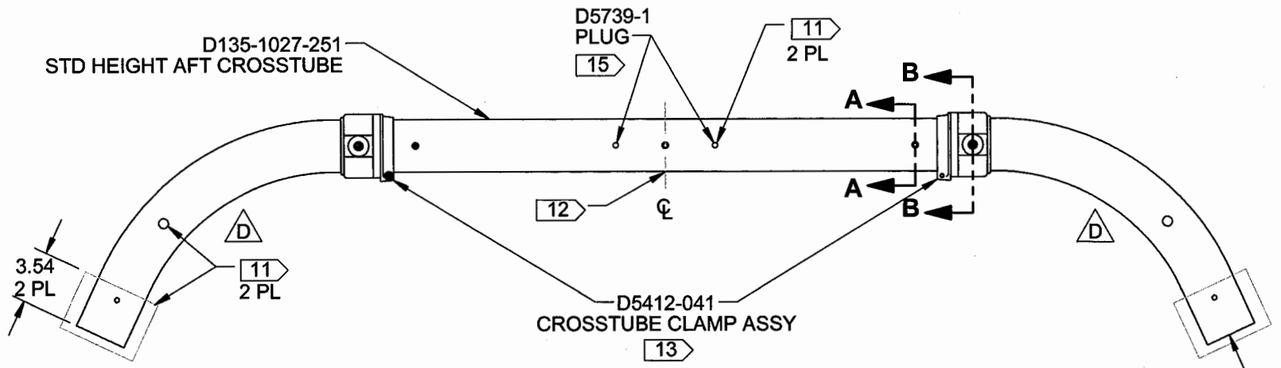
QTY -241	P/N	DESCRIPTION
X	D135-1027-241	STD HEIGHT AFT XTUBE ASSY
1	D135-1027-251	STD HEIGHT AFT CROSSTUBE
2	D5411-1	RUBBER BUSHING
2	D5412-041	CROSSTUBE CLAMP ASSY
2	D5413-1	CROSSTUBE SUPPORT
4	D5414-1	SUPPORT BOLT
3	D5511-1	THREADED ROD
2	D5739-1	PLUG
6	MS35650-304	NUT
6	NAS1149D0363J	WASHER



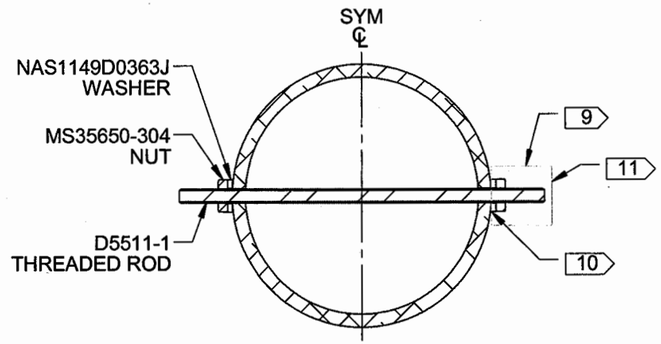
(MEASURED FROM CUFF TO CUFF)



SECTION B-B
2 PL
SCALE 5X



D135-1027-241 STD HEIGHT AFT XTUBE ASSY



SECTION A-A
3 PL
SCALE 5X

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT BARE TUBE PER DART QSI 005 4.1
   PRIME INSIDE AND OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
   PAINT OUTSIDE PRIOR TO SUPPORT INSTALLATION PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: SCRIBE DART P/N "D135-1027-241" AND B/N ON INSIDE OF CUFF PER DART QSI 044 6.4 (VIBRATING STYLUS)
7) WEIGHT: 20.24 LBS
8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
9) PRIOR TO PRIME AND PAINT, APPLY 1 DROP OF LOCKTITE 263 TO THE MATING THREADS OF D5511-1 IMMEDIATELY PRIOR TO INSTALLING AND TORQUING THE MS35650-304 NUT TO 5-10 IN-LBS
10) PRIOR TO PRIME AND PAINT, FILLET SEAL USING PR1422 B1/2 OR P/S-890 B1/2 SEALANT
11) MASK PRIOR TO PRIME AND PAINT
12) AFTER FINISHING MARK THE ENTIRE CIRCUMFERENCE OF THE CROSSTUBE CENTERLINE (± 0.1") PER QSI 044 6.1
13) PRESS D5412-041 CROSSTUBE CLAMP TIGHT AGAINST D5411-1 RUBBER BUSHING THEN TORQUE BOLT TO 50-70 IN-LBS
14) IT IS ACCEPTABLE TO USE MILD SOAP AND WATER OR A SMALL AMOUNT OF WATER BASED LUBRICANT TO INSTALL THE SUPPORTS
15) WET INSTALL D5739-1 PLUGS USING PR1422 B1/2 OR P/S-890 B1/2 SEALANT

RELEASED
2022 MAR 18
H3 ECR 366

APPROVED

REV.	DESCRIPTION	BY	DATE
D	REMOVE STEP HOLES, REASON ECR 366	SAD	22.02.11
C	ADDED QTY (2) D5739-1	MW	19.09.11
B	ADDED D5411-1, D5412-041, D5413-1, AND D5414-1 REVISED NOTES, ADDED SECTION B-B	ZF	18.10.04
A	NEW ISSUE	AJS	17.07.13

DESIGN	ML	**DART AEROSPACE LTD**
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D135-1027-241 REV. D
MFG. APPR.	DD	SHEET 1 OF 1
APPROVED	CP	TITLE STD HEIGHT AFT XTUBE ASSY
DE APPR.	CP	SCALE NTS
DATE	22.02.11	

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